

Work Order ID 66080



Page 1

Thursday, February 03, 2011 3:13:22 PM

Item ID: D2121	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Clamp					
Start Date: 2/4/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 2/18/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-02-03</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2121	Rev D

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld washer & wing nut as per Dwg D2121 & QSI 004 Identify as Wing Nut assembly								

EL 11-3-18 (X8)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

FL 11-03-18 8 φ

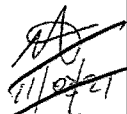
120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121.								
	Drill and deburr hole in coupling nut as per Dwg D2121. (Note: Install MS21042L4 Nut loosely)								

8 11/03/23 (8) 8 11/03/21 ATC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/21	120	250 Hole is approx 1000 off center line of piece, piece moved in vise u/a S			 11/03/21 u/a			

NOTE: Date & initial all entries

Work Order ID 66080

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Thursday, February 03, 2011 3:13:22 PM

Item ID: D2121

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 2/4/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 u/03/23

Memo

0.00

(48)

140



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PAP 66072

0.00

11/3/23

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/23

C 21/03/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66080

Parent Item: D2121

Parent Item Name: Clamp



Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: D04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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5/16WC 		Purchased	No			120	Each	2,014.000	1	8			
SS Flat Washer 5/16 FW516S1													

Location	Loc Qty	Loc Code
ST377	2014	
112560	176	
114758	77	
115072	14	8
115110	293	
115174	32	
116385	100	
116473	100	
116643	1222	

AN4-4A 		Purchased	No			120	Each	158.0000	1	8			
Bolt													

Location	Loc Qty	Loc Code
ST356	157	
114615	157	8
ST361	1	
111295	1	

AN960JD416 	NAS1149D0463J	Purchased	No			120	Each	30.0000	1	8			
Washer													

Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

M116805 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 66080

Parent Item: D2121

Parent Item Name: Clamp

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 8.00

Required Qty: 8.00

D2012-107

Manufactured No

120

Each

15.0000

1

8



Clevis



EL 11-3-3

Location

Loc Qty

Loc Code

ST004

15

62242

15

120

Each

530.0000

5

40

D2529

Manufactured No



Washer



EL 11-3-3

Location

Loc Qty

Loc Code

ST017

530

64127

530

120

Each

3,744.000

1

8

MS21042L4

Purchased No



Nut



EL 11-3-3

Location

Loc Qty

Loc Code

ST300

3744

1123143

2

115589

10

115621

21

116188

3500

116548

211

8

SS. 5/16-18SS wingnut. -> M160/6 x8. EL 11-3-18.

- 5/16-18SS Threaded Rod cut at 65

M115198

- D2771-BCFC-025-150

cut at 1-50"

M117194

qty 1 m 9754

SB

11/03/23

8

SB

11/03/23

8

- D2771-LCC-025

qty 1 m 9493

SB

11/03/23

8

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Shop Packet Print

Page 2

- 5/16-18 1" coupling nut

qty 1 m160/6

SB

11/03/23

8

- 5/16-18 Jam nut

qty 1 m 1160/6

SB

11/03/23

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

△ C 5/16" WC SS WASHER

#66080

5/16-18 WING NUT

5/16-18 THREADED ROD
6.5 LONG

D2771-BCFC-025-150 SS BOLT (1)*
(CUT TO LENGTH AS REQUIRED)

D2529 SS WASHER (5)*

D2771-LCC-025 SS LOCK NUT (1)*

*OR EQUIVALENT

5/16-18 JAMNUT

STAINLESS STEEL
5/16-18 1" COUPLING NUT
D2012-107 CLEVIS

AN4-4A BOLT
AN960JD416 WASHER
MS21042L4 NUT, INSTALL LOOSE

DRILL THRU 1/4 (.250) DIA

1.00

0.281

RELEASED
04.05.04



D	C	B	-	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR	
1	2	3	4	DRAWN		BASIC CODE	DIA. DASH NO. 9-HEAD NEAR SIDE 9-HEAD FAR SIDE	CONTRACT NO.	DART DART AERO ACCESSORIES INC. VANCOUVER CANADA				
5	6	7	8	APPROVED		D-COMPILE DASH NO. OF SHEETS C-COUNTERSHEET	LENGTH DASH NO. W-SPOTWELD	DESIGN	DATE				
9	10	11	12	DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 32+2 5. HOLES PER AND 10087 1. TOLERANCES - .005 & .030 2. ANGLES .010 3. PARALLELISM .0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BASIC CODES 88-M204726AD 88-M204726AD	DRAWN DESIGNED CHECKED CLIENT	TITLE CLAMP, BATTERY CODE DZ121 SCALE NTS	DWG NO. DZ121 SHEET 1 OF 1	REV. D	

REPORT ALL DISCREPANCIES - DO NOT SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Battery Box Clamp		Part Number:	D2121
Drawing: D2121 Rev. D		Qty:	
		Page 1 OF 2	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler																																																			
2	WS	<p>Weld washer & wing nut as per Dwg D2121 & QSI 004</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>5/16-18 SS Wing Nut ✓</td> <td>Wing Nut</td> <td></td> </tr> <tr> <td>1</td> <td>5/16WC ✓</td> <td>Washer</td> <td></td> </tr> </tbody> </table> <p>Identify as Wing Nut assembly</p>	Qty	Part Number	Description	Batch	1	5/16-18 SS Wing Nut ✓	Wing Nut		1	5/16WC ✓	Washer																																								
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5	QC5	Inspect work to Step 4																																																			
6	ST	Identify and Stock																																																			
7	AC	Cost / part: _____																																																			
8	DC	Close W/O Inspect Level 21																																																			

DART AEROSPACE LTD	Work Order:	
Description: Battery Box Clamp	Part Number:	D2121
Drawing: D2121 Rev. D	Qty:	
		Page 2 OF 2

Rev	Date	Change	Revised By	Approved
A	99.05.17	New Issue	DM	
B	99.09.08	Change Dwg to rev. B	EC	
C	03.02.03	Added hardware per Rev. C	KJ/RF	
D	04.05.27	Added Step 2-3; changed Step 4	KJ/JLM	

